

MUST SHIP FRIDAY OCT 30

Work Order ID 53261

October 29, 2009 11:03:05 AM

Page 1

Item ID: D3700-3

Accept

Setup Start

Revision ID: B

Stop

Item Name: Outboard Window Doubler

Start Date: 10/29/09 Start Qty: 3.00

Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3700

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3700 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

IB 9-10-09



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-10-09

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 8/25/10/09



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Page 2

Item ID: D3700-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Outboard Window Doubler

Start Date: 10/29/09 Start Qty: 3.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BF 09-10-29			(4)			
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	MD 09/10/29			24			
150 Packaging Packaging	Identify as per dwg & Stock Location <u>126</u> Memo	0.00 0.00				9/10/29 (40) SV			

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Item ID: D3700-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Outboard Window Doubler

Start Date: 10/29/09 Start Qty: 3.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/30

ME

09-10-29

Picklist Print

October 29, 2009 11:03:04 AM

Page 1

Work Order ID: 53261



Parent Item: D3700-3RevB



Parent Item Name: Outboard Window Doubler



Start Date: 10/29/09

Required Date: 10/30/09

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.050  6061-T6 .050 Sheet		Purchased	No				sf	43.0053	8.4300 			189-10-29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

43.00523158

110791

34.5715

112567

6.43373158

17349

2

112567

W/O
53261

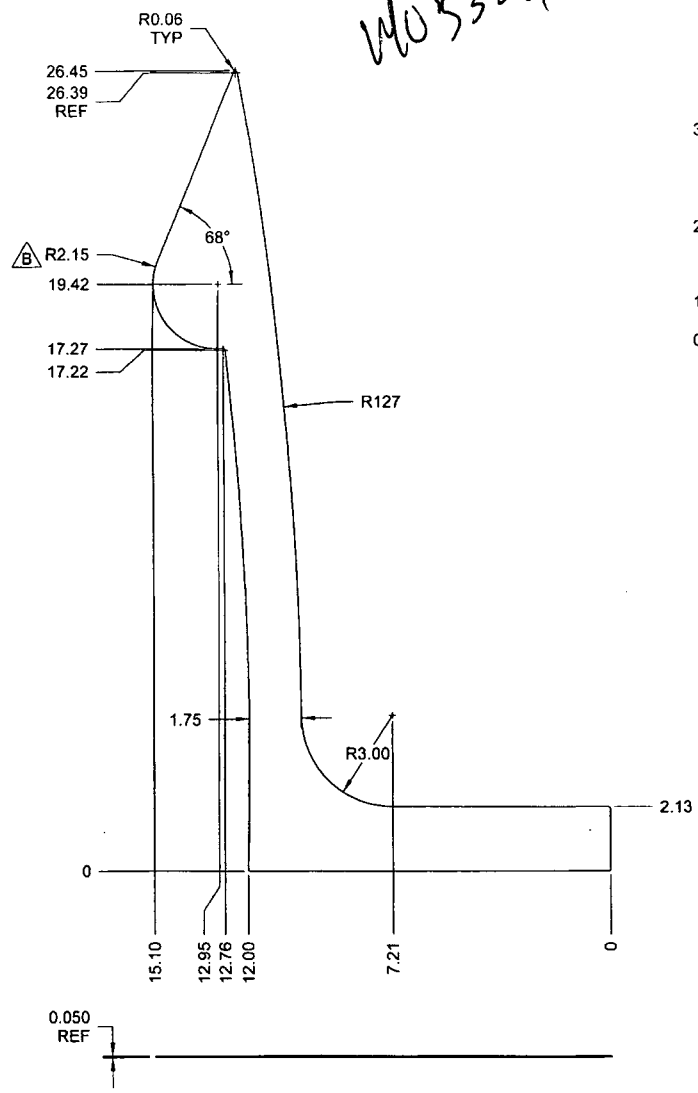
D3700-1 INBOARD WINDOW DOUBLER

D3700-3 OUTBOARD WINDOW DOUBLER

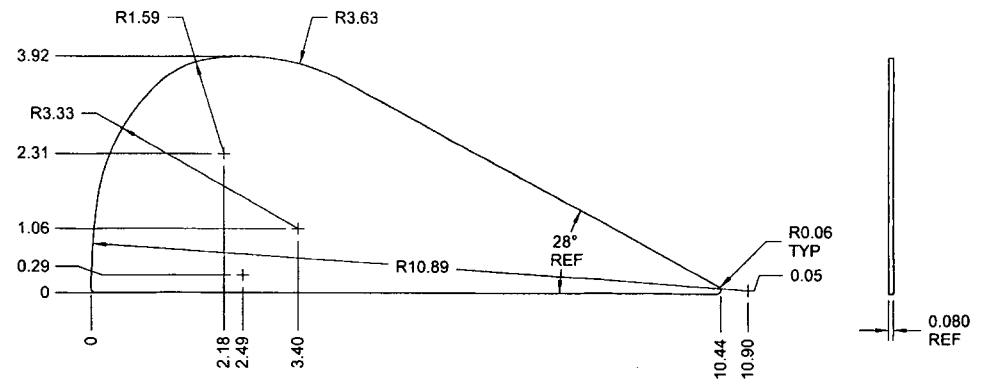
RELEASED
09/03/18

B	ADDED 0.25" TO TOP PROFILE OF D3700-1 (ZN D8-2); REDIMENSION PARTS; REMOVED REFERENCES TO DXF FILES (NOTES 8 AND 9).	MB	09.03.18
A	NEW ISSUE	MB	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3700	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	NTS
DATE	09.03.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W053261



D3700-3 OUTBOARD WINDOW DOUBLER



D3700-1 INBOARD WINDOW DOUBLER

RELEASED
8/24/09 AM

- NOTES:**
- 1) MATERIAL:**
D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.050)
 - 2) FINISH:** CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES:** PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS:** INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES:** 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION:** IDENTIFY WITH DART P/N "D3700-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT:** D3700-1 = 0.20 lbs
D3700-3 = 0.37 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3700	SHEET 2 OF 2
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